

# Work Order ID 63922

November 19, 2010 7:25:56 AM

Page 1

Item ID: D212-725-1-175F

Accept

Revision ID:

Item Name: Pilon Web

Setup Start

Stop

Start Date: 11/19/10 Start Qty: 3.00

Required Date: 11/19/10 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *W*

Date: 10/11/22

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D212-725-1

F

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *F*

Prog Rev: *F*

2024.028

2-Deburr if necessary

B10-1-22

(3)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-1-22

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Item ID: D212-725-1-175F

Accept



Setup Start



Revision ID:

Item Name: Pilon Web

Stop



Start Date: 11/19/10 Start Qty: 3.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*10/11/22*

*(73)*

*10/11/22*

*Y3*

*Lead 4/22 (3)*

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Item ID: D212-725-1-175F

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Item Name: Pilon Web

Start Date: 11/19/10 Start Qty: 3.00

Required Date: 11/19/10 Req'd Qty: 3.00

Reference:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Identify as per dwg & Stock Location: 385

0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

CK 10/11/23  
MF  
10-11-22

# Picklist Print

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Work Order ID: 63922

Parent Item: D212-725-1-175F

Parent Item Name: Pilon Web



Start Date: 11/19/10

Required Date: 11/19/10

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.025		Purchased	No			100	sf	48.0000	0.941	2.971579			



ALUM SHEET .025



1810-1-22

Location

Loc Qty

Loc Code

MAT

48

116076

48

116076

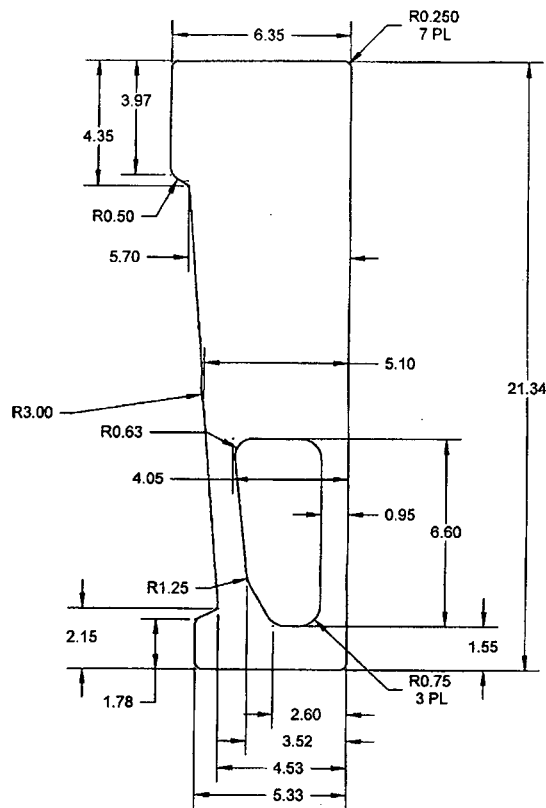
0212-750-1-175F

X	First Article	X	Prototype
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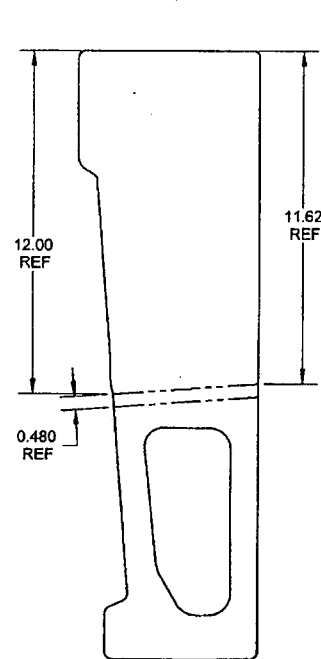
Measured by:	KB
Date:	10-11-22

Prototype Approval:	
Date:	

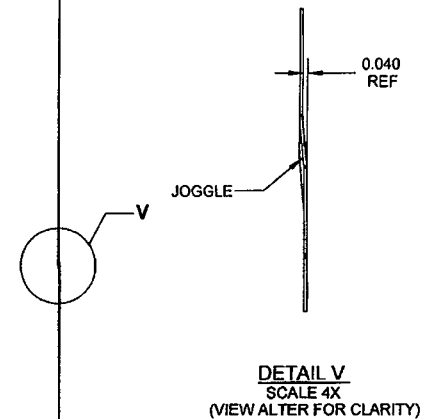
H:\FORMS\Quality Assurance\approved QA\FAI revD



**D212-725-1-175F FLAT PATTERN**



**D212-725-1-175 WEB SHOWN  
D212-725-1-176 OPPOSITE  
(MAKE FROM D212-725-1-175F FLAT PATTERN)**






**RELEASED**  
09/04/07

**NOTES:**

- 1) MATERIAL: 2024-T3 SHEET 0.025 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.025)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL UPON INSTALLATION
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

*WLO 63922*

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. F
MFG. APPR.		D212-725-1	SHEET 59 OF 84
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
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